

D4804-041 BIPOD ASSEMBLY, AFT (EQUIVALENT TO BELL P/N 407-060-111-101)

С

1) MATERIAL: N/A

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8

7) WEIGHT: 1.28 lbs

8) ALIGN PILOT HOLES IN D4807-041 WITH PILOT HOLES IN D4804-1.
ALIGN PILOT HOLES IN D4808-041 WITH PILOT HOLES IN D4804-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (\$\phi\$0.1610) REAMER, USING DART TOOL SETUP DT9954

9) INSTALL PIN/COLLAR AND ROD END WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
10) ASSEMBLE PER DART TOOL DT9954
11) INSTALL HL32PB5-8 HI-LOK IN ORIENTATION SHOWN

В	REVISE NOTES 6), 7) & 9) (ZN A8-1); ADDED BELL P/N			RF	14.04.08
Α	NEW ISSUE			RF	13.09.16
REV.	-	[DESCRIPTION	BY	DATE
DESIGN DRAWN		RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
		RF			
CHECKED		VS	DRAWING NO.		REV. C
CHECKED MFG. APPR.		JLM	D4804	SHEET 1 OF 3	
APPRO	VED	HS ,	TITLE		SCALE
DE APPR.		DS-#	- BIPOD ASSEMBLY, AF		NTS
DE APPR. DS DATE 14.06.24			COPYRIGHT @ 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY DURPOSE OR COMPLEO OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		
	A REV. DESIGN DRAWN CHECK MFG. AI APPRO DE APP	A NEW IS: REV. DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR.	A NEW ISSUE REV. C DESIGN RF DRAWN RF CHECKED VS MFG. APPR. JLM APPROVED HS DE APPR. DS	A NEW ISSUE REV. DESCRIPTION DESIGN RF DART AEROSPAC DRAWN RF HAWKESBURY, ONTARIO, CHECKED VS DRAWING NO. DFAMING NO.	A NEW ISSUE REV. DESCRIPTION DESCRIPTION BY DESIGN RF DART AEROSPACE L HAWKESBURY, ONTARIO, CANA CHECKED VS DRAWING NO. D4804 APPROVED HS DE APPR. DATE 14 06 24 DESCRIPTION BY DART AEROSPACE L HAWKESBURY, ONTARIO, CANA COPYRIGHT © 2013 BY DART AEROSPACE THIS DOCUMENT IS PRINTER AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRES

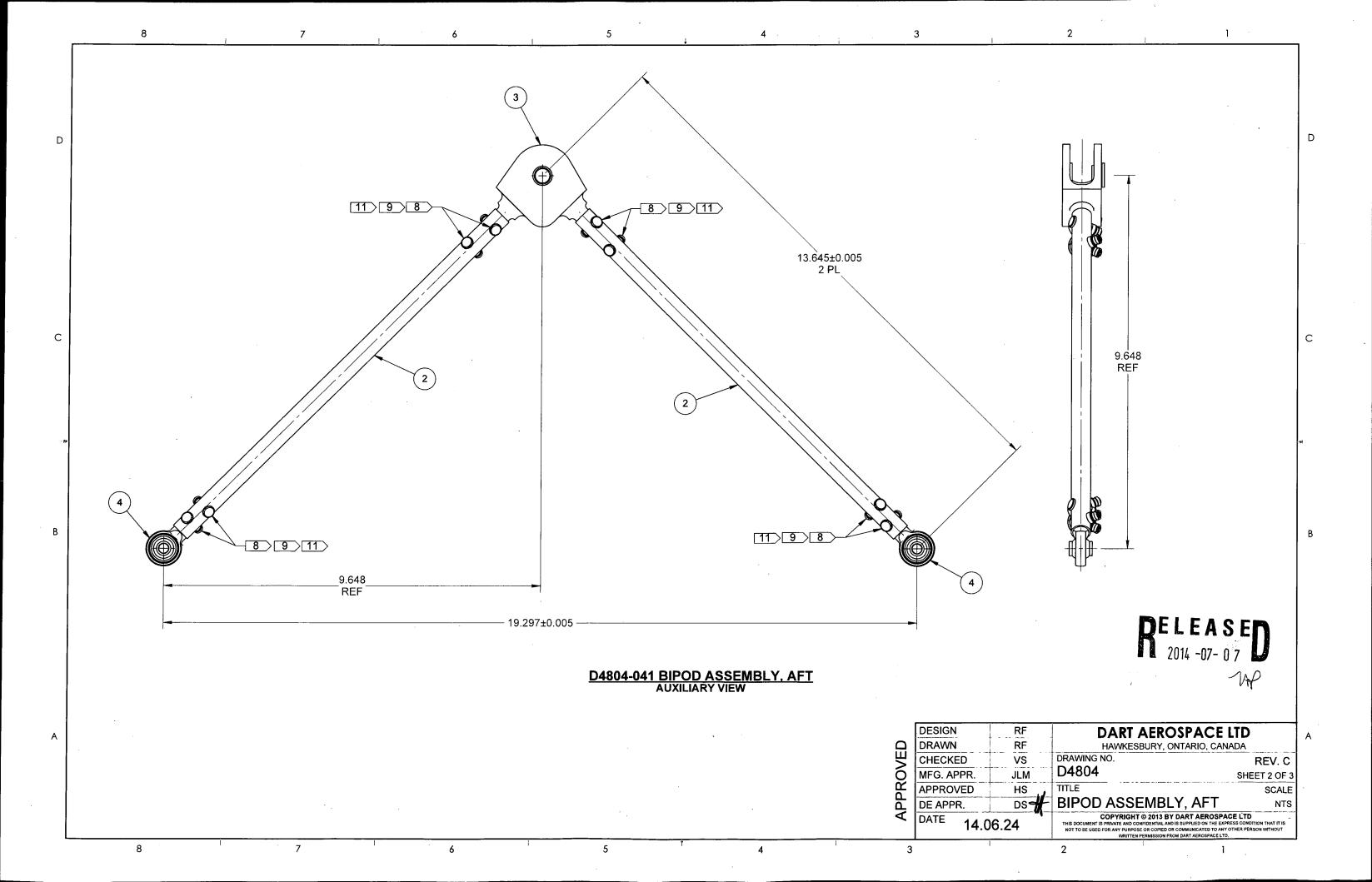
HL32PB5-8 WAS HL20PB5-8 (ZN D4-1); REVISE NOTE 6) (ZN A8-3)

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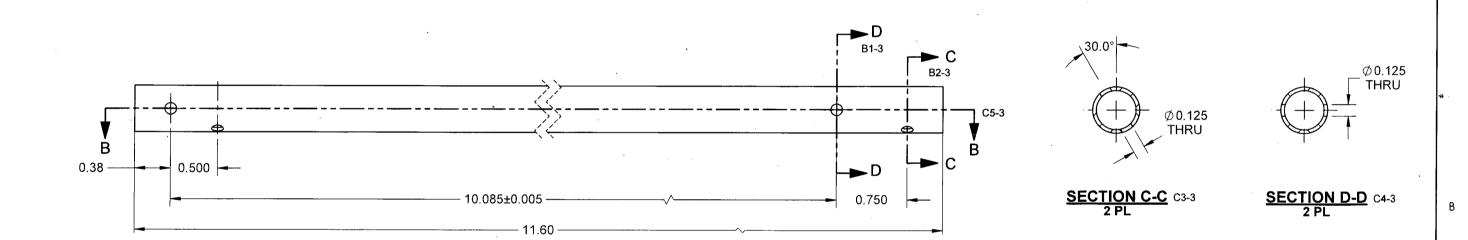
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14.06.24



R0.13 Ø 0.422^{+0.001}_{-0.000}_ Ø0.500 2 PL Ø 0.394 **- 1.28** -REF 2 PL 0 0

SECTION B-B B3-3



D4804-1 STRUT

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION PER AMS 5643/ASTM A564 DART SPEC M17-4-R

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3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6

7) WEIGHT: 0.23 lbs

8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

DESIGN RF DRAWN RF **APPROVED** CHECKED VS MFG. APPR. JLM APPROVED HS DE APPR DATE 14.06.24

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C D4804 SHEET 3 OF 3 TITLE SCALE **BIPOD ASSEMBLY, AFT**

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